

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008652**Date Inspected:** 06-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Segment 4BE**

This QA inspector performed MT of temporary attachment and tack weld removal areas on DP 48A after repair areas previously inspected and accepted by ZPMC QC.

**Segment 4BW**

This QA inspector performed MT of temporary attachment and tack weld removal areas on DP 47A after repair areas previously inspected and accepted by ZPMC QC.

**Bay#2- Segment 1AAW**

This QA inspector verified of root opening in PJP joints in all Seg1E Stiffeners, because of improper dimensional and joint fit up. ZPMC QC removes those stiffeners by thermal cutting and carbon arc gouging. ZPMC QC Zhu Tian Shu and ABFJV Wang Wen Bin were present during observation. The weld joint numbers are designated as below.

-(Seg1F-023, 024, 025, 026)

-(Seg1E-043, 044)

-(Seg1E-254+164)

-(Seg1C-026)

-(Seg1E-152+242)

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-(Seg1C-050)  
-(Seg1E-362+320)  
-(Seg1C-128)  
-(Seg1E-148+238)  
-(Seg1C-058)  
-(Seg1E-353+311)  
-(Seg1D-146)  
-(Seg1E-137+227)  
-(Seg1D-150)  
-(Seg1E-347+305)  
-(Seg1D-128)  
-(Seg1E-341+299)  
-(Seg1D-108)  
-(Seg1E-340+298)  
-(Seg1D-105)  
-(Seg1E-422+380)  
-(Seg1D-107)  
-(Seg1E-337+295)  
-(Seg1D-096)  
-(Seg1E-045, 046, 334)  
-(Seg1F-002, 003, 004, 005)

### Bay#2- Segment 1AAE

This QA inspector verified of root opening in PJP joints in all Seg1E Stiffeners, because of improper dimensional and joint fit up. ZPMC QC removes those stiffeners by thermal cutting and carbon arc gouging. ZPMC QC Zhu Tian Shu and ABFJV Wang Wen Bin were present during observation. The weld joint numbers are designated as below.

-(Seg2F-002, 003, 004, 005)  
-(Seg2E-369+327)  
-(Seg2C-104)  
-(Seg2E-362+320)  
-(Seg2C-127)  
-(Seg2E-152+242)  
-(Seg2C-150)  
-(Seg2E-151+241)  
-(Seg2C-041)  
-(Seg2E-361+319)  
-(Seg2C-130)  
-(Seg2E-355+313)  
-(Seg2C-148)  
-(Seg2E-137+227)  
-(Seg2D-044)  
-(Seg2E-347+305)  
-(Seg2D-130)

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-(Seg2E-338+296)  
-(Seg2D-101)  
-(Seg2E-334)  
-(Seg2F-023, 024, 025, 026, 027)

Bay #3

This QA inspector observed the following work in progress:

FCAW welding of weld joint LD011-014-003, 004, 001, 002, 005, 006 located on LD011-014. Welder is identified as 204338 (3G). ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB020-008-041, 057 located on FB020-008. Welder is identified as 208035 (2G). ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB020-008-056, 040 located on FB020-008. Welder is identified as 044790 (2G). ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint FB012-034-013, 014 located on FB012-034. Welder is identified as 048038 (2G). ZPMC QC is identified as Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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